



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBWSI-HT-12AS-3
Job Sheet 171524



Part No: RBWSI-HT-12AS-3

Job Qty: 10 ea

Part Name: Base



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/2/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBWSI-HT-12AS Rev E IPP Rev A 18.02.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		2/8/18	0.00	0.00	Start Up Machining-2		SL 18-2-7
110	CNC Lathe	10 pcs		2/9/18	0.00	2.50	MORI SL-154		SL
120	QC	10 pcs		2/9/18	0.00	0.00	QC2 Machining-4		SL
130	QC	10 pcs		2/9/18	0.00	0.00	QC8 Machining-4		SL 18-2-7
150	Outsource	10 pcs		2/9/18	0.00	0.00	Outsource4		AT 18/02/20
160	Packaging	10 pcs		2/9/18	0.00	0.00	Packaging2		AT 18/02/20
170	QC	10 pcs		2/9/18	0.00	0.00	QC6		38/11
180	Packaging	10 pcs		2/9/18	0.00	0.00	Packaging3-1 GA		FEB 23 2018
190	QC21-SA	10 Ea		2/9/18	0.00	0.00	QC21		FEB 28 2018

Part Op 110 - 1-Machine as per DWG. FB 812 FOLIO REV: 21 DWG REV: 21 2-Deburr
Descriptions: 150 - Issue P/O to ATG : PO 038709 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE 2 CLASS-2, Water sealant -Certificate of Conformity is required
FEB 12 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.250	6061-T6 Round Bar 1.250	.6000 ft (.06 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.250	1	56	0
	SC08425	.57		

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S039783

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Base

PART NO: RBWSI-HT-12AS-3

Original Serial #: S039783

Revision:

Operation:

Change No:

Start up Operation 02/07/18

Job No: 171524

DQA: _____ Date: _____



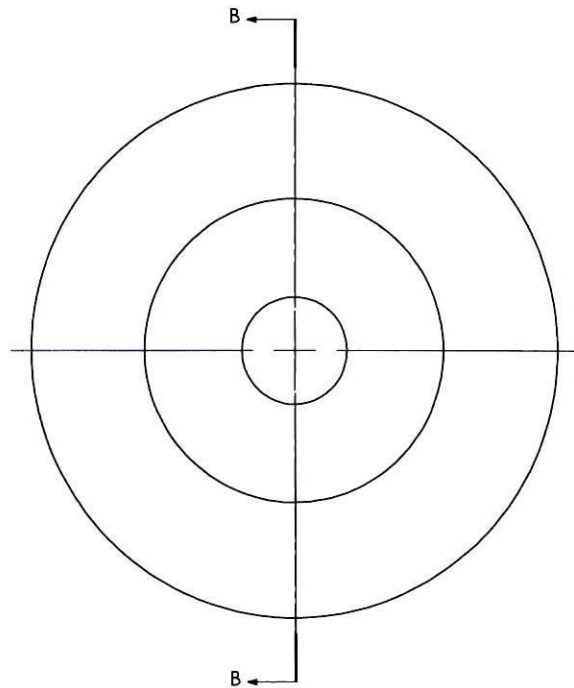
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

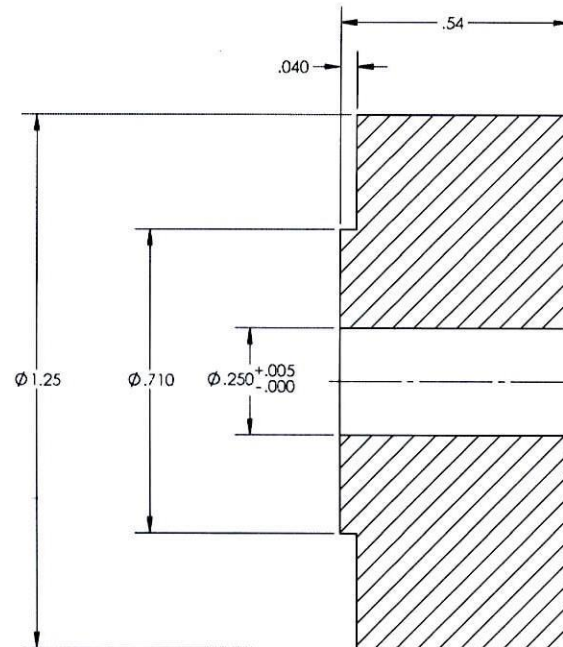
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

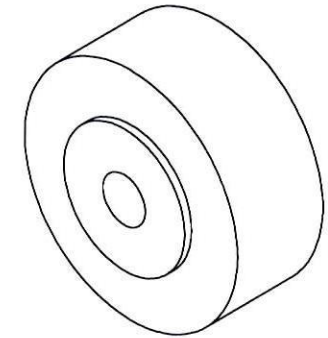
REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
E	DIMENSION .250 CHANGED FOR .250 +.005/-0. TEMPLATE UPDATED	18-506	18.1.12	VM	ML



RBWSI-HT-12AS-3 BASE



SECTION B-B



SHOP COPY
RETURN TO
ENGINEER NO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171524
MLJ
180202

- NOTES:**
- 1) MATERIAL: 6061-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: RED ANODIZE
 - 4) SPEC: MIL-A-8625, TYPE II, CLASS 2: WATER SEALANT
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A

		Hawkesbury, Ontario, Canada	
TITLE BASE			
PART NO. RBWSI-HT-12AS-3		REV E	
TOOL NO. RBWSI-HT-12AS		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY: VM 1/12/2018	INITIALS AND DATE	TOLERANCES: XXX ± .008 FRACTIONS ± 1/8 XX ± .01 ANGLES ± .5° X ± .1 SURFACE ROUGHNESS	
DRAWN BY: VM 01/12/2018			
CHECKED BY: VM 01/12/2018			
MFG REVIEW BY: DD 01/18/2018			
APPROVED BY: ML 01/31/2018		SCALE: NTS	SHEET 3 OF 3
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PURCHASE ORDER

PO038709

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			Doubler Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N As Per Dwg 647.0100 Rev. B							
7	170540	RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3205-00T Rev/ 3C	Firmed	2/21/18	6 pcs	0 pcs	6 pcs	\$20.12/pcs	\$120.72
						✓ 6x			AT 18/02/22	
8	171524	RBWSI-HT-12AS-3	Base -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As per Dwg RBWSI-HT-12AS Rev. E	Firmed	2/21/18	10 pcs	0 pcs	10 pcs	\$11.65/pcs	\$116.50
						✓ 10x			AT 18/02/22	
						DAS 11 9-89			DAS 38 9-89	
Grand Total:										\$963.97

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Handwritten signature and initials.



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914649

Date: 22-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
2 ea	Part: 647.2114 Upper U Channel Anodize as per MPP-172 sect. 2.1 2 -Pretreatment as per MPP-172 sect 3.3 3-Prime as per MPP-172 sect 4.3 Job: 22527	Rev: E PO: PO038709 Line: 1	
6 ea	Part: RBE350A93-3205-00E Engine G/B Input Flange Hoidin Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (4 - 1 mils). Water Sealant Job: 22531	Rev: 2A PO: PO038709 Line: 5	
6 ea	Part: RBE350A93-3205-00T Tail Rotor Gear Box Input Flan Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (4 - 1 mils). Water Sealant Job: 22533	Rev: 3C PO: PO038709 Line: 7	
10 ea	Part: RBWSI-HT-12AS-3 Base Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (4 - 1 mils). Water Sealant Job: 22534	Rev: E PO: PO038709 Line: 8	DAS 11 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements.			
Date: 22/2/18			
Certified Signature: <i>J. Res. Richard</i>			
Receiver Signature: _____			
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
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Canada

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Number: 914649

Date: 22-Feb-18

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1270 Aberdeen St
Hawkesbury, ON K6A 1K7

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Ph: 613 632-9577

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Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.		
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		